



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2661-2
Job Sheet 208676



Part No: D2661-2

Job Qty: 4 pcs

Part Name: Saddle, RH, Fwd, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/30/20

Job Tracking No:

Due Date: 4/15/20

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV E IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP REV:D REDESIGN
PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs	4/14/20		1.00	6.56	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 20/04/20
							HAAS - 4		DJP 20/04/23
110	Conventional Mill - 1 - B4B	4 pcs	4/14/20		0.00	0.26	Conventional Mill - 1 - B4B		
							Conventional Mill - 2 - B4B		
120	QC 2	4 pcs	4/14/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



Container No: S272382



Part: D2661-2
Job No: 208676
Serial No/Batch: S272382
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/22/20

Plex 3/30/20 1:09 PM Dart.Renwick.Jennifer

				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	20-04-23
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
130	QC 8	4	4/14/20	0.00 0.00	QC 8 - 12
	pcs				QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
140	Handfinish - 1-1 Chemical-B4B	4	4/14/20	0.00 0.11	Handfinish - 1 - 1 - B4B
	pcs				Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B
					Handfinish - 1 - 17 - B4B
					Handfinish - 1 - 18 - B4B

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				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 1 White GI(A)- B4B 4 pcs 4/15/20				0.00 0.15	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
160 QC 3 4 pcs 4/15/20				0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
					QC 3 - 61
					QC 3 - 81
					QC 3 - 82
					QC 3 - 87
170 Packaging 3-1 - Stock - B4B 4 pcs 4/15/20				0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 37 - B4B
180 QC 21 - SA 4 pcs 4/15/20				0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
					Broussard
Part Op 100 - (HAAS CNC Vertical Machine), Program part number and batch number MACHINE AS PER DWG AND FOLIO					
Descriptions: FB071 FOLIO REV: AA DWG REV: E					
110 - (Manufacture as per dwg), Machine Keyway and inspect per attached dimension sheet					
120 - QC2- Inspect parts off machine FAI/FAIB					
130 - QC8- Inspect parts - second check					

1254469

START: 11:58 W.T. 130° FINISH: 12:20

20-04-23

9-89

9-89

68-9

59

DAS

9-89

28

DAS

9-89

70

DAS

APR 23 2020

Plex 3/30/20 1:09 PM Dart.Renwick.Jennife

140 - Chemical Conversion Coat per QSI005 4.1**150** - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

160 - QC3- Inspect Part Finish**170** - Identify as per dwg & Stock Location: *5401***180** - QC21- Final Inspection - Work Order Release**Job BOM**

Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	4 pcs (1 ea)	100-HAAS 4 Axis	<i>S269790</i>

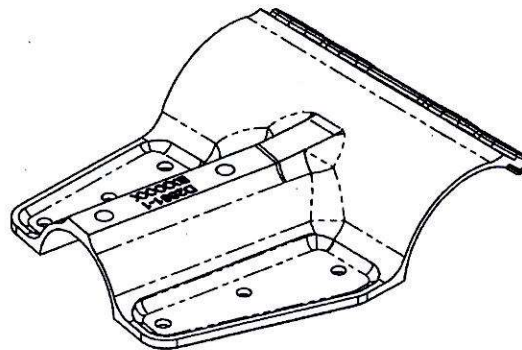
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-003	4	36	0

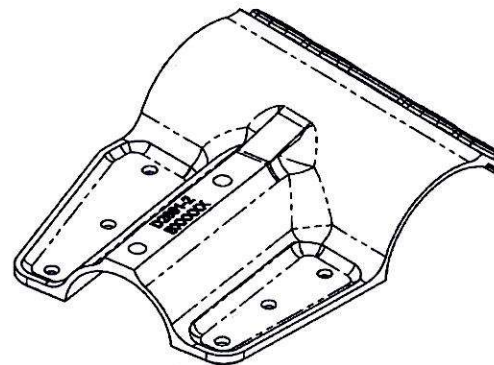
Part Specifications

Specifications could not be found.

Plex 3/30/20 1:09 PM Dart.Renwick.Jennifer



D2661-1 SADDLE, OUTSIDE, LH



D2661-2 SADDLE, OUTSIDE, RH

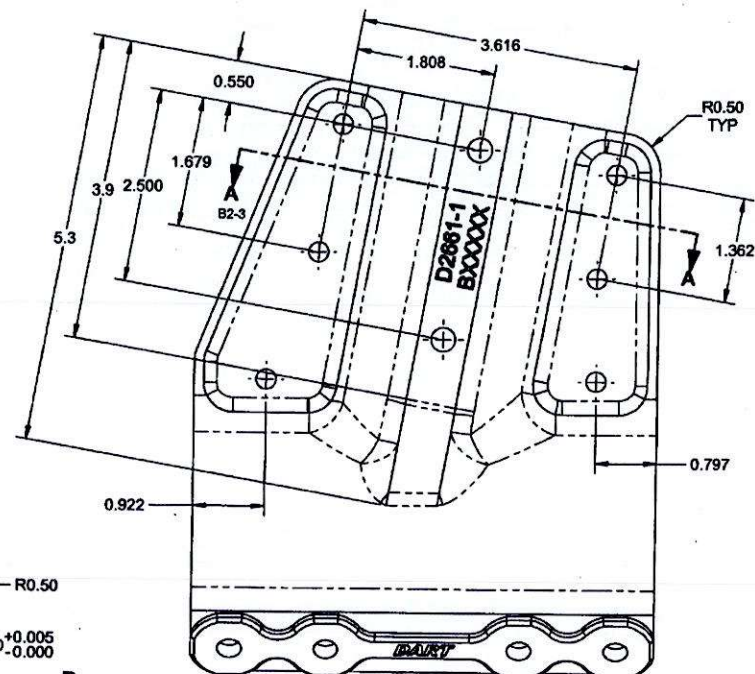
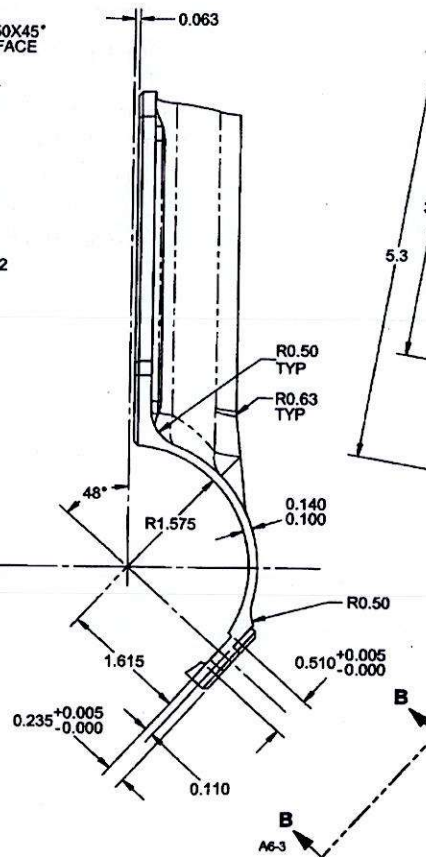
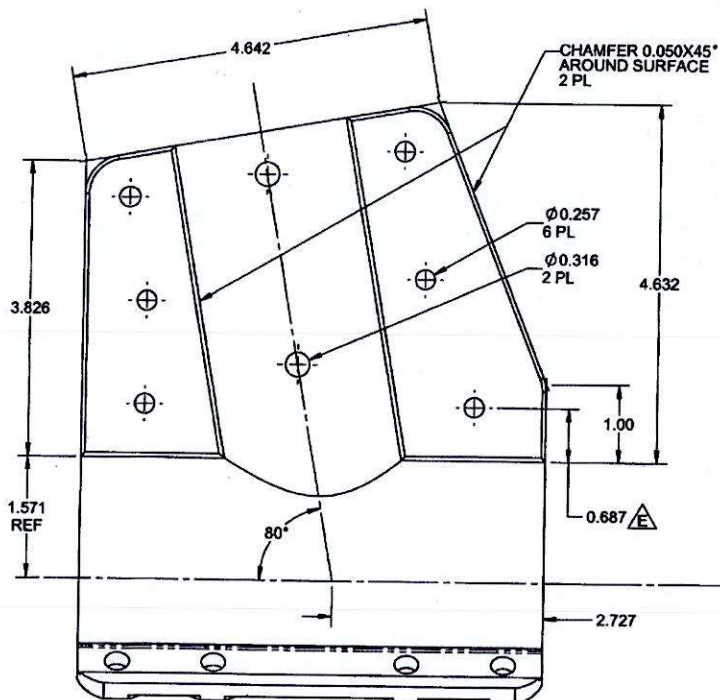
RELEASED
2011-11-16

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 208676

E	REDRAW & REFORMAT DWG; 0.547 WAS 0.547 (B6-2,B6-4), REF NCR 11-835	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.318 WAS Ø0.313	CB	08.11.08
C	INCORPORATE DEO #122, #102, 9085	CB	08.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.31		

DART AEROSPACE USA, INC. KENT, WA		REV. E
DRAWING NO.	D2661	SHEET 1 OF 5
TITLE	SADDLE, OUTSIDE	SCALE
		NTS

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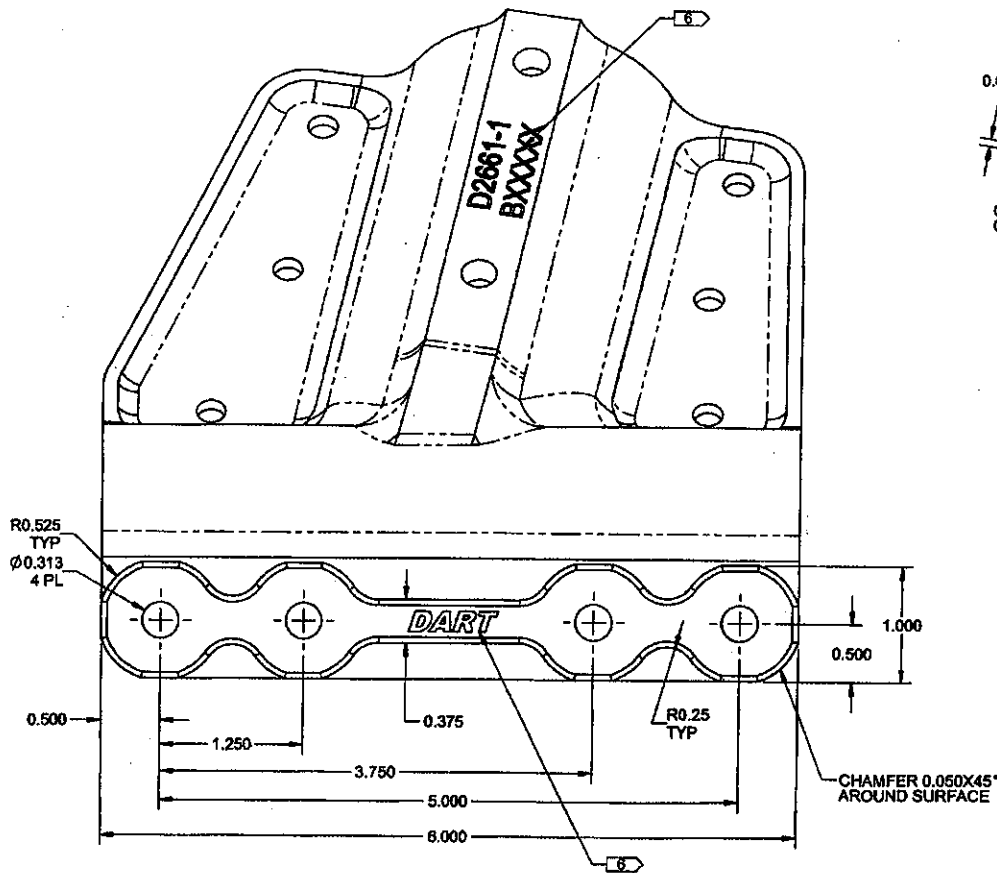


D2661-1 SADDLE, OUTSIDE, LH

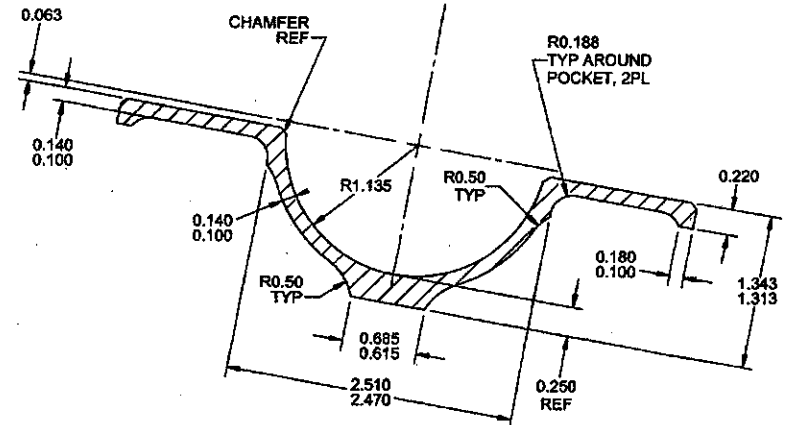
- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

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2011-11-16

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DRAWN	<i>g</i>	KENT, WA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D2661	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE, OUTSIDE	NTS
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VIEW B-B
SCALE 1.5X
VIEW ROTATED

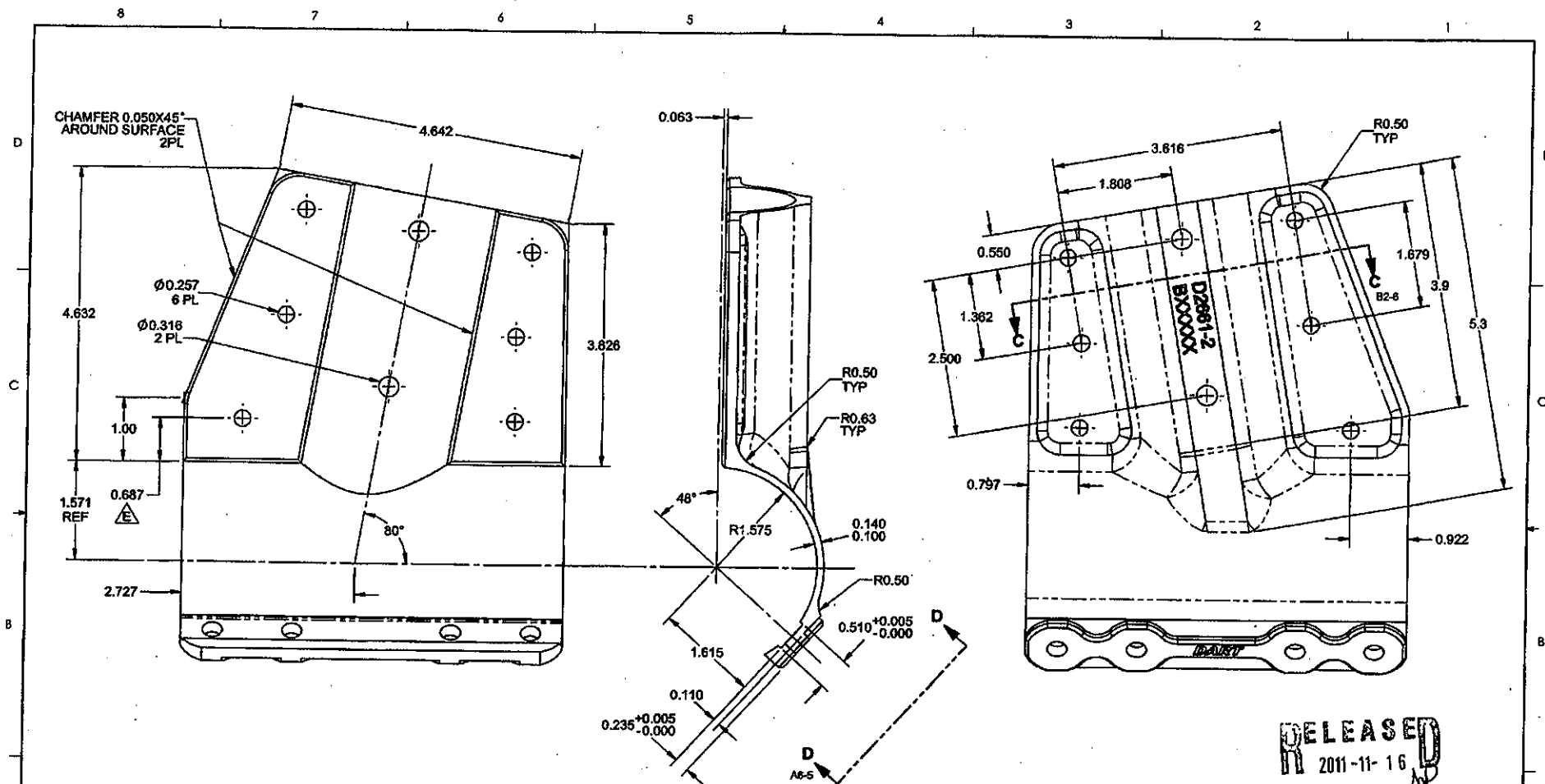


VIEW A-A
SCALE 1.5X

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MFG. APPR.		TITLE SADDLE, OUTSIDE	SHEET 3 OF 5
APPROVED		SCALE	NTS
DE APPR.		DATE 11.10.31	

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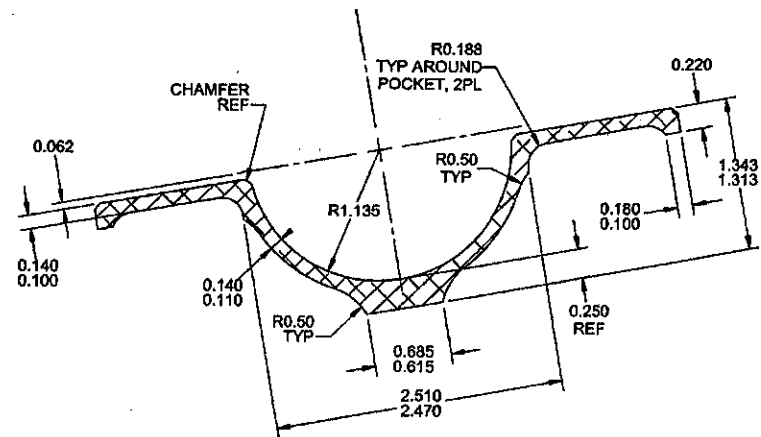
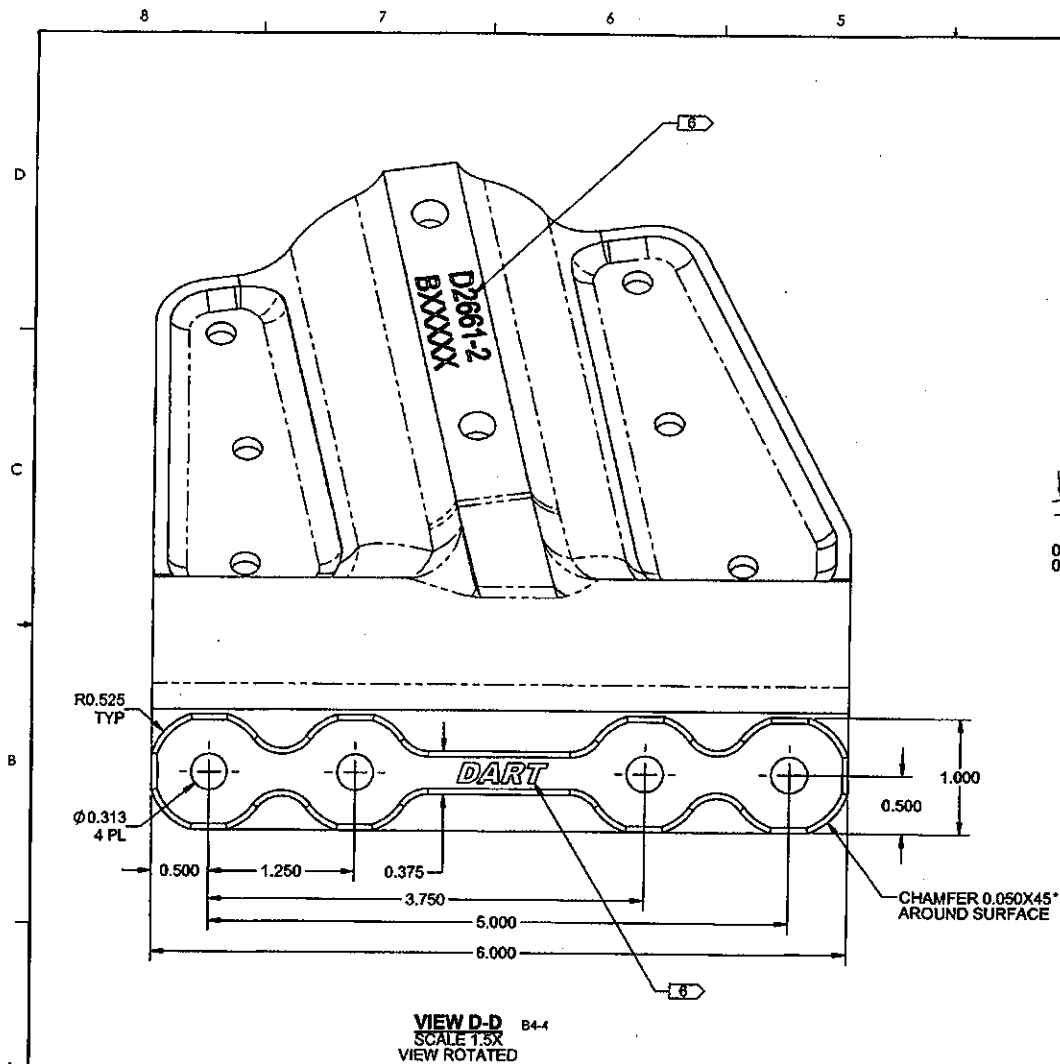


D2661-2 SADDLE, OUTSIDE, RH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

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MFG. APPR.		D2661	SHEET 4 OF 5
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SECTION C-C C1-4
SCALE 1.5X

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DART AEROSPACE LTD		Work Order: 208676
Description: 206 Saddle, Outboard, Right side		Part Number: D2661-2
Inspection Dwg: D2661	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.816	
B	0.256	0.263		.258	.258	.258	0.258	
C	0.315	0.322		.316	.316	.316	0.316	
D	2.495	2.505		2.500	2.500	2.500	2.500	
E	1.674	1.684		1.679	1.679	1.679	1.679	
F	1.357	1.367		1.362	1.362	1.362	1.362	
G	0.100	0.140		.120	.119	.120	0.119	
H	0.210	0.230		.220	.221	.220	0.221	
I	0.615	0.685		.670	.665	.665	0.660	
J	2.470	2.510		2.490	2.492	2.492	2.494	
K	1.313	1.343		1.320	1.320	1.320	1.320	
L	0.178	0.198		.188	.188	.188	0.188	
M	0.470	0.530		.500	.500	.500	0.500	
N	1.125	1.145		1.135	1.135	1.135	1.135	
O	0.100	0.180		.133	0.130	0.130	0.131	
P	0.100	0.140		.132	0.1335	0.135	0.134	
Q	0.240	0.260		.247	0.246	0.246	0.245	
R	0.677	0.697		.689	0.689	0.689	0.689	
S	0.100	0.140		.131	0.125	0.131	0.130	
T	1.565	1.585		1.575	1.575	1.575	1.575	
U	0.540	0.560		.550	0.550	0.549	0.549	
V	0.912	0.932		.921	0.923	0.921	0.922	
W	0.787	0.807		.795	0.797	0.798	0.797	
X	5.990	6.010		6.000	6.000	6.000	6.000	
Y	4.995	5.005		5.000	5.000	5.000	5.000	
Z	0.490	0.510		.500	0.503	0.501	0.505	
AA	0.312	0.319		.313	0.313	0.3135	0.3135	
AB	0.990	1.010		1.005	1.005	1.005	1.005	
AC	1.245	1.255		1.250	1.250	1.250	1.250	
AD	0.490	0.510		.502	0.503	0.505	0.503	
AE	3.745	3.755		3.750	3.750	3.750	3.750	
AF	0.235	0.240		.239	0.239	0.239	0.239	
AG	0.510	0.515		0.511	0.511	0.511	0.511	
AH	0.100	0.120		.110	0.114	0.114	0.114	
Accept/Reject								

Measured by: SBL	Date: 8/6/22
Audited by: 20	Date: 20-04-23
Prototype Approval: 3-89	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	